

Date: Friday, 29/05/2009 8:33:15 AM
 User: Chantal Lavoie

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	GAS SPRING
Job Number :	48286		
Estimate Number :	12941		
P.O. Number :		Part Number :	D355211
This Issue :	29/05/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3552 REV D
First Issue :	//	Project Number :	N/A
Previous Run :	46631	Drawing Revision :	D
	Type :	Material :	
	SMALL /MED FAB	Due Date :	05/06/2009
Written By :		Qty:	10
Checked & Approved By :	<u>C209/05/29</u>	Um:	Each
Comment :	Est Rev:A New Issue 06-11-13 EC Est Rev:B 09-04-20 rev.d as per dwg DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: Issue P/O: 8886 C209/05/29
 Purchase Part Number: B8-240-575-150N
 Supplier: LS Technologies
 Certificate of conformity is required

(10)

2.0	B8 240 575 150N
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
 CARBON STEEL GAS SPRING

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Receive & Inspect For Transit Damage
 Ensure certificate of conformity is attached

(10)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Test for correct pressure

(10)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5T272

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 29/05/2009 8:33:15 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GAS SPRING

Job Number: 48286

Part Number: D355211

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/09 *LA*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-06-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

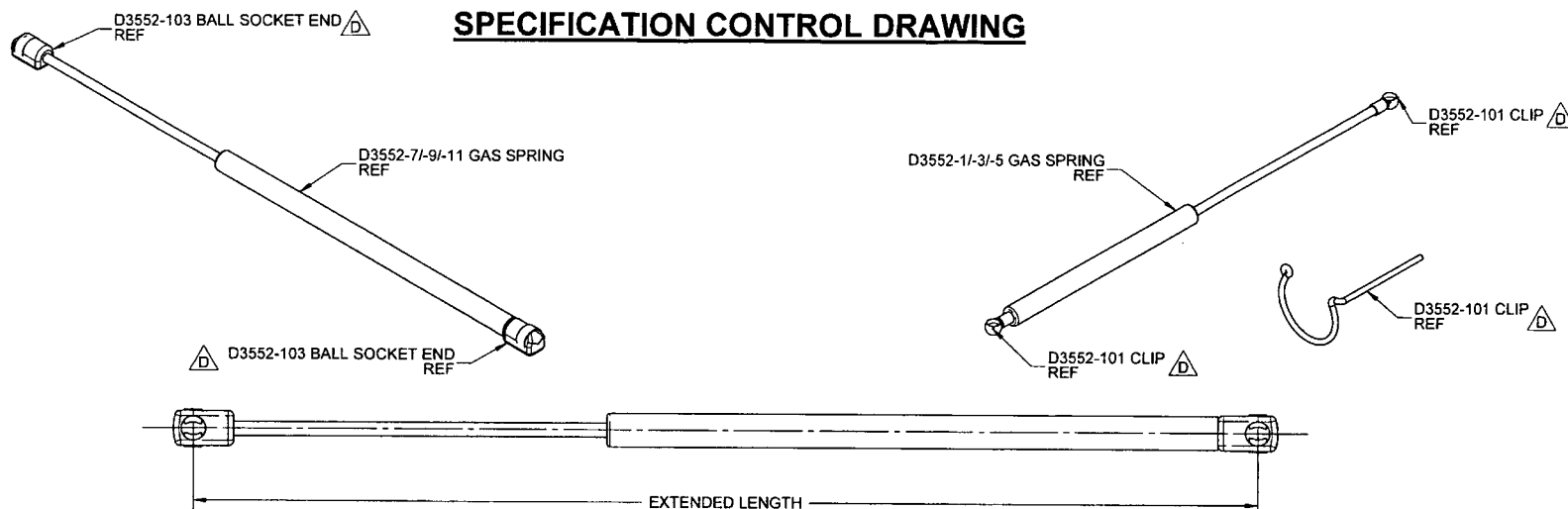
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING



D3552-X GAS SPRING

DART PART NUMBER	DESCRIPTION	STROKE (mm/in)	EXTENDED LENGTH (mm/in)	FORCE (N/lb)	END FITTING	MATERIAL	SUPPLIER	SUPPLIER PART NUMBER
D3552-1	GAS SPRING	220/8.66	530/20.6	70/15.7	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-220-530-070N
D3552-3	GAS SPRING	200/7.87	490/19.3	200/45.0	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-200-490-200N
D3552-5	GAS SPRING	175/6.89	430/16.9	150/33.7	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-175-430-150N
D3552-7	GAS SPRING	220/8.66	530/20.9	70/15.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-220-530-070N
D3552-9	GAS SPRING	200/7.87	490/19.3	200/45.0	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-200-490-200N
D3552-11	GAS SPRING	240/9.45	575/22.6	150/33.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-240-575-150N
D3552-101	CLIP	N/A	N/A	N/A	N/A	CARBON STEEL	LS TECHNOLOGIES	C9
D3552-103	BALL SOCKET END	N/A	N/A	N/A	N/A	NYLON	LS TECHNOLOGIES	B10

RELEASED 09/15/14

C209/05/29
W10: 48286

NOTES:

- IDENTIFICATION: IDENTIFY WITH DART P/N "D3552-X" AND B/N USING WHITE FINE POINT PERMANENT INK MARKER
- D3552-101 CLIP IS ONLY COMPATIBLE WITH D3552-1/-3/-5 GAS SPRINGS
- D3552-103 BALL SOCKET END IS ONLY COMPATIBLE WITH D3552-7/-9/-11 GAS SPRINGS

REV.	DESCRIPTION	BY	DATE
D	ADD P/N D3552-101 ZN D6-1, C7-1, C1-1 AND D3552-103 ZN D1-1 AND C2-1 AND ZN B8-1; ADD NOTE REGARDING D3552-101 AND D3552-103 COMPATIBILITY ZN A8-1		09.04.02
C	ADD D3552-11 AND CONVERSIONS FOR INSPECTION; UPDATE P/N FOR D3552-7	LE	07.06.01
B	ADD D3552-7/-9; UPDATE DESC. D3552-1/-3/-5	LE	06.10.24
A	NEW ISSUE	LE	06.09.15
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	DRAWING NO. D3552		
CHECKED	REV. D		
MFG. APPR.	SHEET 1 OF 1		
APPROVED	TITLE		
DE APPR.	GAS SPRING		
DATE	09.04.02		
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303 - 103rd Street, Saskatoon, Saskatchewan, Canada S7N 1Y9
Ph: (306) 683-5000 Fax: (306) 683-6403
E-mail: lstech@lstechnologies.ca www.liftsupporttechnologies.com

Certificate of Compliance

This is to certify that the parts listed below meets specifications as required by your order.

6 Units: B8-200-490-200N Gas Spring
10 Units: B8-240-575-150N Gas Spring ✓

Country of Manufacture: Canada
Date of Manufacture : 2009
This product is ROHS compliant.

S. L. L. S.

We certify no mercury was used in the manufacture of this order.

Purchase Order # 00008886
Invoice # 5077

L. S. Technologies Inc Canada

A handwritten signature in black ink, appearing to read "Nolan Fehr", written over a horizontal line.

Nolan Fehr
Manager

LS Technologies Canada Inc.

303 - 103 Street
Saskatoon, SK Canada
S7N 1Y9

Packing Slip

P.O. No.	Date	Packing Slip #
8886	6/1/2009	5077

Name / Address
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7 Canada

Ship To
Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7 Canada

Rep	Ship Date	Ship Via
Nolan	6/1/2009	Purolator

Qty	Description
6	B8-200-490-200N Gas Spring
10	B8-240-575-150N Gas Spring
Shipping via PUROLATOR Collect - Tracking # 329098594461	
Total GST Business Number: 875007718	